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**In the Claims:**

1. (Amended) A progressive stamping die for forming a product from a work piece comprising:
  - a first die member;
  - a second die member;
  - an alignment mechanism for maintaining said first and second die members in axial alignment;
  - a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;
  - at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;
  - a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;
  - a biasing member in said second die member in axial alignment with said coin punch member; and
  - a knockout punch member for removing a product from a work piece positioned between said first and second die member; and
  - at least one sensor member in said second die member for determining whether an opening has been formed in a work piece or whether a product has been removed from a work piece.
2. (Original) A progressive stamping die for forming a product from a work piece in claim 1 wherein said biasing member comprises a gas spring member.
3. (Original) A progressive stamping die for forming a product from a work piece in claim 1 wherein said biasing member comprises a mechanical spring member.

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4. (Original) A progressive stamping die for forming a product from a work piece in claim 1 further comprising an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member.

5. (Original) The progressive stamping die for forming a product from a work piece in claim 4 wherein said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member.

6. (Original) The progressive stamping die for forming a product from a work piece in claim 1 further comprising a scrap chute in said second die member at least in part in axial alignment with said pierce punch member.

7. (Amended) The progressive stamping die for forming a product from a work piece in claim 1 further comprising a product collection chute in said second ~~die~~ die member at least in part in axial alignment with said knockout punch member.

8. (Amended) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment; ~~and~~

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members; and

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at least one sensor member in said second die member for determining that a product is formed from a work piece.

9. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said spring member is a gas spring member.

10. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said spring member is a mechanical spring member.

11. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said biasing mechanism further comprises at least one anvil member.

12. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 11 wherein each of said anvil members comprises a puck member, a bottom disk member, a bottoming member, and a return pin member.

13. (Amended) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein each of said chute ~~member~~ means comprises a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

14. (Original) A method of forming a metal ring member from a work piece with a progressive stamping die, said method comprising the steps of:

positioning a work piece between a first stamping die member and a second stamping die member;

forming an opening in said work piece with pierce punch member;

indexing said work piece in said die member with at least one pilot member;

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forming an annular ring member around the opening with a coin punch member, said annular ring member having a predetermined thickness and flat planar dimension by use of a biasing mechanism in axial alignment with said coin punch member; and

removing said formed annular ring member from said die with a knockout punch member.

15. (Original) The method of forming a metal ring member from a work piece with a progressive stamping die in claim 14 wherein said biasing mechanism comprises a gas spring mechanism.

16. (Original) The method of forming a metal ring member from a work piece with a progressive stamping die in claim 14 wherein said biasing mechanism comprises a mechanical spring member.

17. (New) A progressive stamping die for forming a product from a work piece as described in claim 1 wherein a pair of sensor members are provided for determining whether an opening has been formed in a work piece or whether a product has been removed from a work piece.

18. (New) A progressive stamping die for forming a product from a work piece as described in claim 1 wherein at least one sensor member is provided for determining whether an opening has been found in a work piece and at least one sensor is provided for determining whether a product has been removed from a work piece.

19. (New) A progressive stamping die for forming a product from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die members in axial alignment;

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a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;

at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;

a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;

a biasing member in said second die member in axial alignment with said coin punch member;

an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member, said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member; and

a knockout punch member for removing a product from a work piece positioned between said first and second die member.

20. (New) A progressive stamping die for forming a product from a work piece in claim 19 wherein said biasing member comprises a gas spring member.

21. (New) A progressive stamping die for forming a product from a work piece in claim 19 wherein said biasing member comprises a mechanical spring member.

22. (New) The progressive stamping die for forming a product from a work piece in claim 19 further comprising a scrap chute in said second die member at least in part in axial alignment with said pierce punch member.

23. (New) The progressive stamping die for forming a product from a work piece in claim 19 further comprising a product collection chute in said second die member at least in part in axial alignment with said knockout punch member.

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24. (New) A progressive stamping die for forming a product from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die members in axial alignment;

a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;

a scrap chute in said second die member at least in part in axial alignment with said pierce punch member;

at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;

a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;

a biasing member in said second die member in axial alignment with said coin punch member; and

a knockout punch member for removing a product from a work piece positioned between said first and second die member.

25. (New) A progressive stamping die for forming a product from a work piece in claim 24 wherein said biasing member comprises a gas spring member.

26. (New) A progressive stamping die for forming a product from a work piece in claim 24 wherein said biasing member comprises a mechanical spring member.

27. (New) A progressive stamping die for forming a product from a work piece in claim 24 further comprising an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member.



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28. (New) The progressive stamping die for forming a product from a work piece in claim 27 wherein said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member.

29. (New) The progressive stamping die for forming a product from a work piece in claim 24 further comprising a product collection chute in said second die member at least in part in axial alignment with said knockout punch member.

30. (New) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment; and

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members and at least one anvil member, each of said anvil members comprising a puck member, a bottom disk member, a bottoming member, and a return pin member.

31. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein said spring member is a gas spring member.

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32. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein said spring member is a mechanical spring member.

33. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein each of said chute means comprises a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

34. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 further comprising at least one sensor member in said second die member for determining whether a product has been formed from a work piece.

35. (New) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment;

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members; and



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each of said chute means comprising a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

36. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said spring member is a gas spring member.

37. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said spring member is a mechanical spring member.

38. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said biasing mechanism further comprises at least one anvil member.

39. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 38 wherein each of said anvil members comprises a puck member, a bottom disk member, a bottoming member, and a return pin member.

40. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 further comprising at least one sensor member in said second die member for determining whether a product has been formed from a work piece.